

Tuesday, 19/08/2008 11:19:51 AM

User: Julie Lecocq

## Process Sheet

**Customer** : CU-DAR001 Dart Helicopters Services  
**Job Number** : 41387  
**Estimate Number** : 10528  
**P.O. Number** :  
**This Issue** : 19/08/2008 **S.O. No.** :  
**Prsht Rev.** : NC  
**First Issue** : / / **Type** : CROSSTUBES  
**Previous Run** : 41386  
**Written By** :  
**Checked & Approved By** : JLD 08.8.19  
**Comment** : Est Rev:C 05.09.02 Add holes for compatibility with Bell Skidtubes KJ/JLM  
 Est Rev:D Added Magnobond, Rubber Cushion & Clamps 07-02-19 JLM  
  
 \*\*\*\*CHANGE TO CHG 005 - IF USING D2894-1 B35578 OR GREATER\*\*\*\*  
 Est Rev:E 08-05-22 add comment in seq. 6 and QC15 and QC5 DD verified by:EC  
 Est Rev:F 08-06-12 add comment in seq. 24 DD verified by:EC

**Drawing Name** : 407 HIGH AFT X-TUBE ASSEMBLY  
**Part Number** : D407667205  
**Drawing Number** : D407-667-245 L/R # 08.08.20  
**Project Number** : N/A  
**Drawing Revision** : E 08/08/20  
**Material** : F E 08-11-17  
**Due Date** : 26/08/2008 **Qty:** 1 **Um:** Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
2.0	PACKAGING 1	PACKAGING RESOURCE #1
3.0	D407667205TRN	Crosstube Turning Detail
4.0	BENDING	BENDING MACHINE - SKIDTUBES



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D407-667-205CHG004

SOSLUBS CHG006

JLD 08.08.20



Comment: PACKAGING RESOURCE #1



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B39854

08-11-4



Comment: LANDING GEAR RESOURCE 1

1-Bend tube as per Dwg D407-667-245 using CNC bender program 407 Aft and Folio F

JLD 08-11-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41387

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

08-11-05

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245

6-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D407-667-245. Note: Aft side has 3x top holes.

7-Drill Fwd rivet holes using drill Jig DT8789 as per Dwg D407-667-245. Drill only the top (3) holes.

8-C'sink holes as per Dwg D407-667-245. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-245

10- Scribe tube to identify on the inner chamfer in the cuff D# and B#

MB 08-11-6

MB 08-11-07

MB 08-11-05

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MB 08-11-7

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-07

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-11-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41387

Part Number: D407667205

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting OUTSIDE SERVICES  
Liquid Penetrant Inspection as per QSI 038Or  
Issue P/O: 512 LPI as per ASTM 1417  
Level 2 Attach copy of NDT results to work order

*0208/11/10*

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Inspect for transit damage  
Ensure copy of NDT results attached to work order.

*0208/11/10*

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*0208-11-13*

*(PTC)*

13.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

*ml 08 11 13 (1)*

14.0	QC14	INSPECT SPRAY PAINT
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Comment: Inspect Spray Paint  
Wrap in plastic bag to protect from scratches

*PT 08 11-17*

15.0	D2856400	Abrasion Strip
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Comment: Qty.: 1.3524 f(s)/Unit Total: 1.3524 f(s)  
Pick:  
Qty Part number Description Batch  
2 D2856-400(Cut to 7.73") Abrasion Strip 37667

*PT 08-11-17*

16.0	D2873043	Nut Plate Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Pick:  
Qty Part number Description Batch  
2 D2873-043 Nut Plate 40218

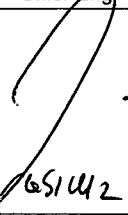




*45 08-11-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

See NCR 08-114

Part No: D407-667-205 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: H Date: 08-11-21

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>41387</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-11-13	12.0	The incorrect NDT results were attached to the W/O's. P.C. Past NDT results were used as a reference, it was included in the new results, submitted to Dart.		See NCR 08-114 - Attach the correct NDT results.	 08/11/13	 08-11-13	 08/11/13	 08-11-13

NOTE: Date &amp; initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41387

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 38316

RT 08-11-12

18.0

D28941

2.750 Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2894-1 Support 21475

RT 08-11-14

19.0

D31901

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3190-1 Chafing Shield 37969

RT 08-11-17

20.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0246 sf(s)/Unit Total : 0.0246 sf(s)

Rubber Cushion D3595-063-450

2X .750" X 4.30"

Batch:

B 41108 & 6 OKAY TO USE  
450 RT 08-11-12  
RT 08-11-12

21.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet 108521

RT 08-11-12

22.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22 Clamp 107356

RT 08-11-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 41387

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp(per MIL-DTL-8783C)

Batch: 108976

25 08-11-14

24.0

CROSSTUBES

CROSSTUBES-RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8674. Install chafing shield as per Dwg D407-667-245. Note:  
(3) top holes should be facing up.

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3-Install support with magnobond and install clamps as per Dwg D407-667-245 using installation jig DT9025.  
Torque clamps to 80-100 in lb

A/R Magnobond

Batch:

108966

EXP:

09-04-01

RT  
08-11-14

→ RT  
08-11-14

4-Install nut plates as per Dwg D407-667-245. Touch-up rivet heads with Imron paint. RT 08-11-12

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/17 (X)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: 1109061

8/11/17

(X)

S

D 407 667 205 B 41387

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41387

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Nut  
Batch: MS289

SP

29.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)  
Pick:Packing Kit  
Qty Part number Description Batch  
10 AN5-10A Bolt M108990

M109282

SP

30.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Pick:Packing Kit  
Qty Part number Description Batch  
4 AN5-32A Bolt M109028

SP

31.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)  
Pick:Packing Kit  
Qty Part number Description Batch  
18 AN960JD516 Washer M5813

M109282

8/11/17

SP

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/08/18

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and in kanban rack  
Location: 53

Rev e - 8/11/18

SP

34.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/21

Job Completion



mf 08-11-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

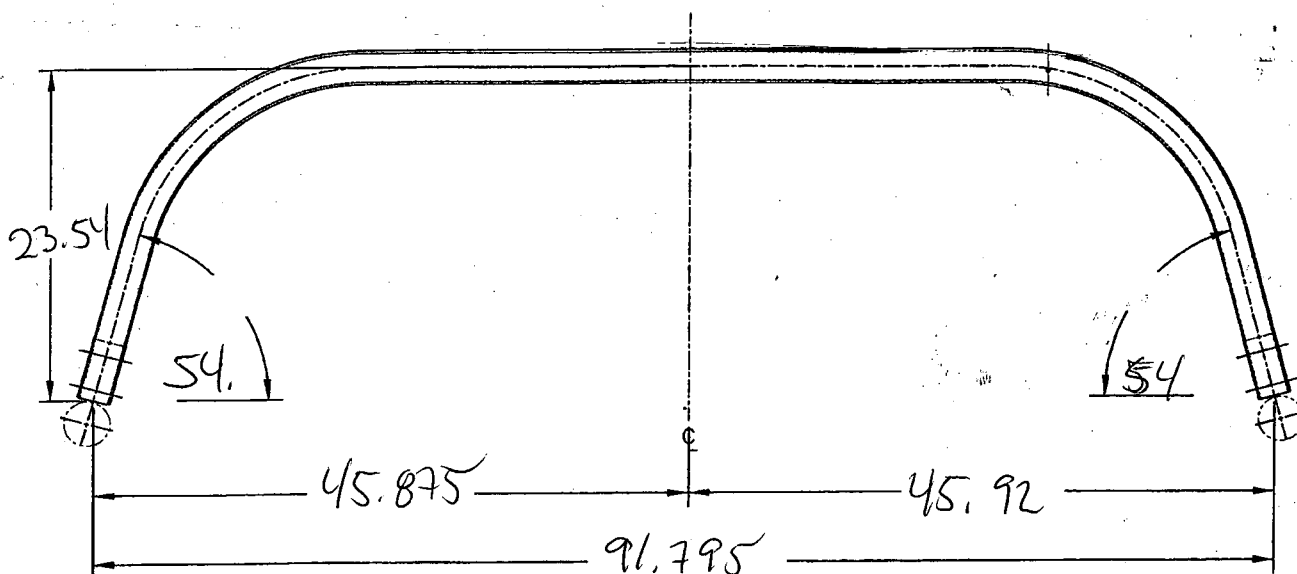
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41387
<b>Description:</b> Crosstube High Aft (407)		<b>Part Number:</b> D407-667-205
<b>Inspection Dwg:</b> D407-667-245 <b>Rev:</b> D		<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	45.86	45.98
Angle	54	56
Total Span	91.72	91.96



Comments

QC15 Inspection	
Date	08-11-05

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

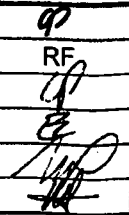
Item	QTY -245	PART NUMBER	DESCRIPTION
1	X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
2	1	D6011-115	CROSSTUBE
3	2	D2856-400-773	ABRASION STRIP
4	2	D2873-043	NUT PLATE
5	2	D2873-045	NUT PLATE
6	1	D2894-1	SUPPORT
7	2	D3190-1	CHAFING SHIELD
8	2	D3595-063-430	RUBBER CUSHION
9	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
10	4	MS21920-22	CLAMP
11	2	MS21920-25	CLAMP (OR MS21920-24)
12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

# GENERAL NOTES:

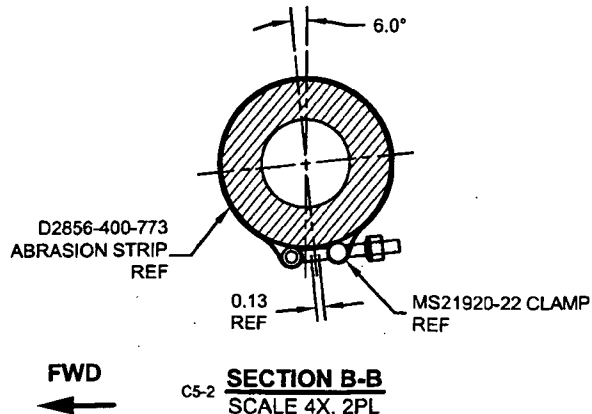
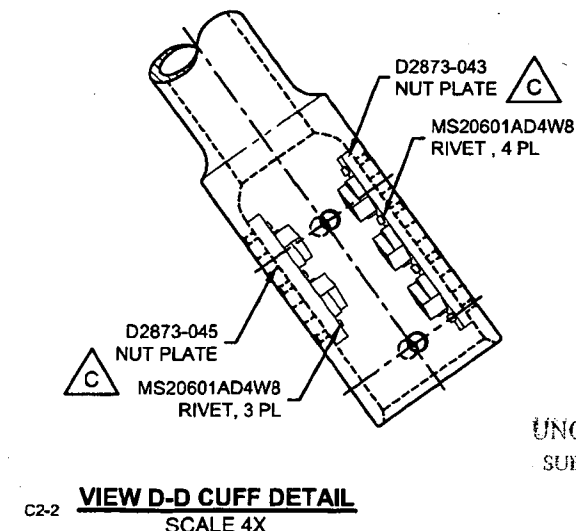
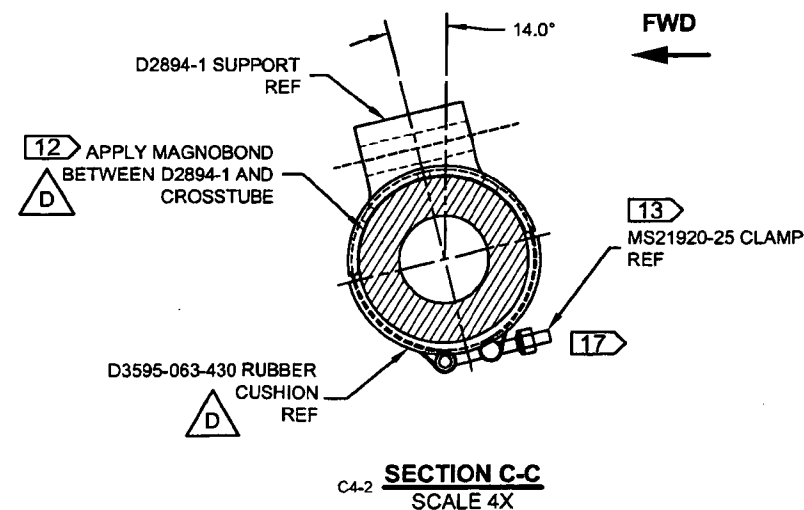
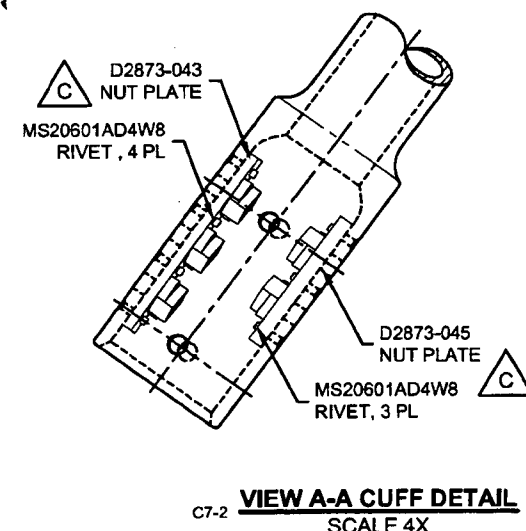
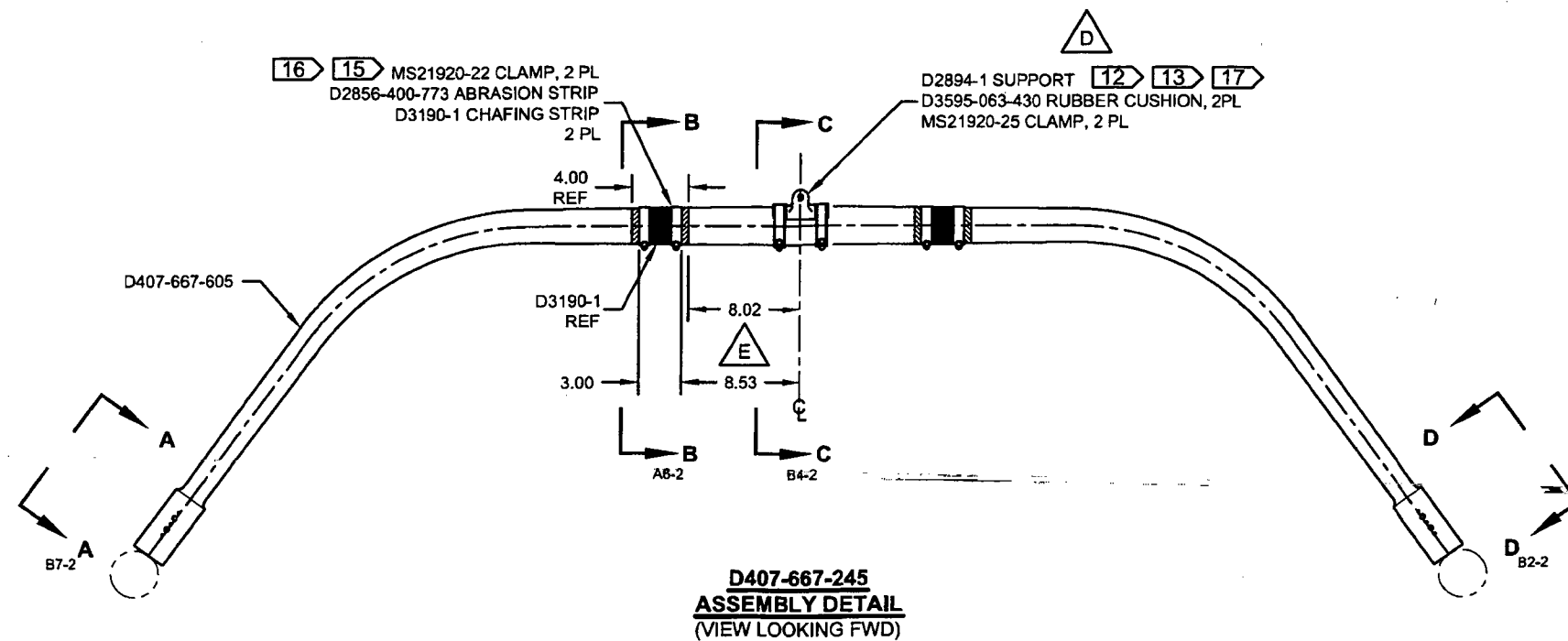
- MATERIAL: MANUFACTURED FROM D6011-115  
FINISHED LENGTH = 112.91±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 27.7 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.  
**NOTE:** MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, PER QSI 035.
- INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41387

RELEASED  
08/11/12





F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)	RF	08.11.06
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR#08-21 AND ECN#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. F
CHECKED		D407-667-245	SHEET 1 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		CROSSTUBE ASS'Y (407 HIGH AFT)	NT
DE APPR.			
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





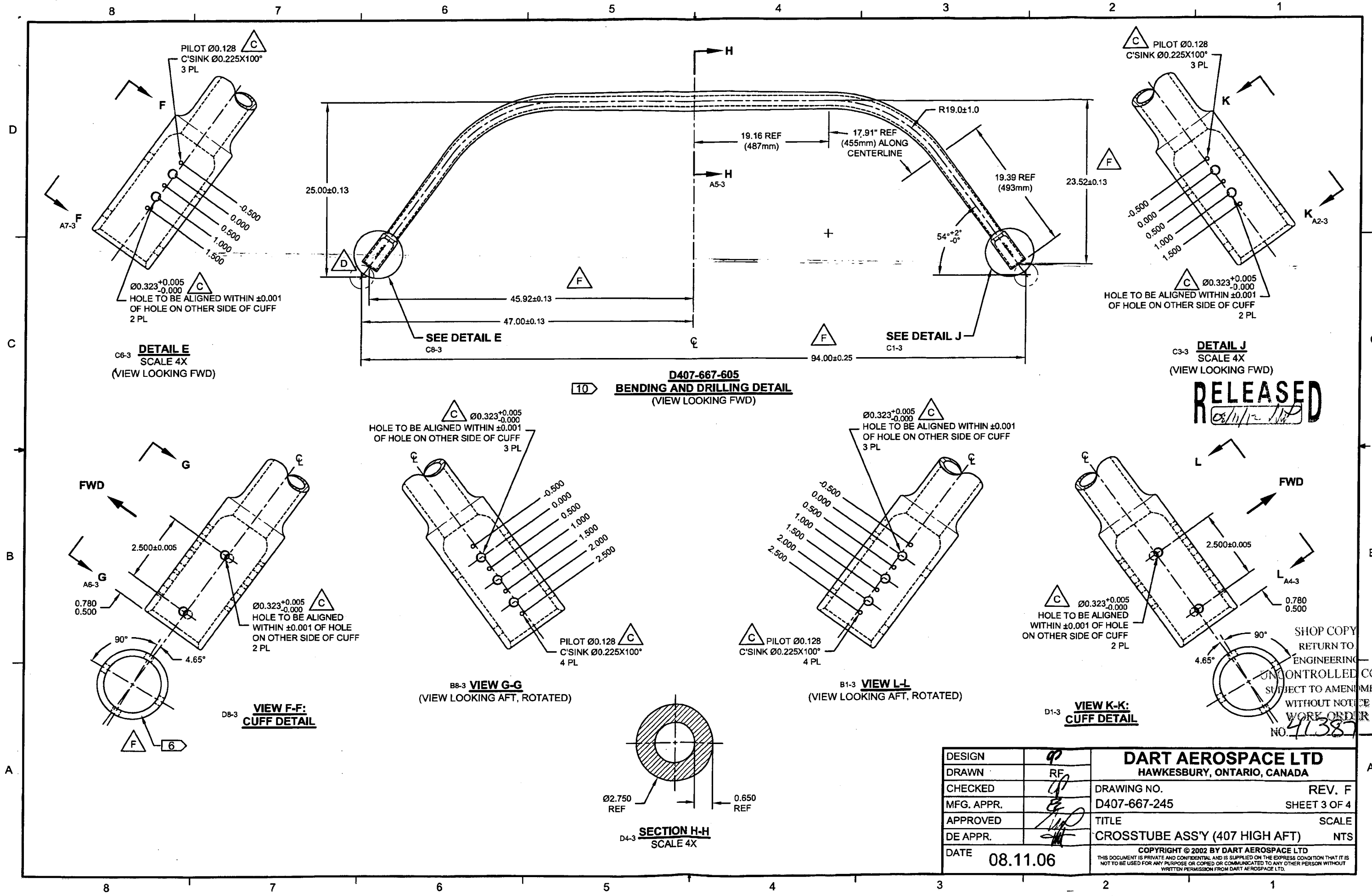
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WITHOUT NOTICE  
WORK ORDER  
NO. 411387

**RELEASED**  
08/11/12

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D407-667-245	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
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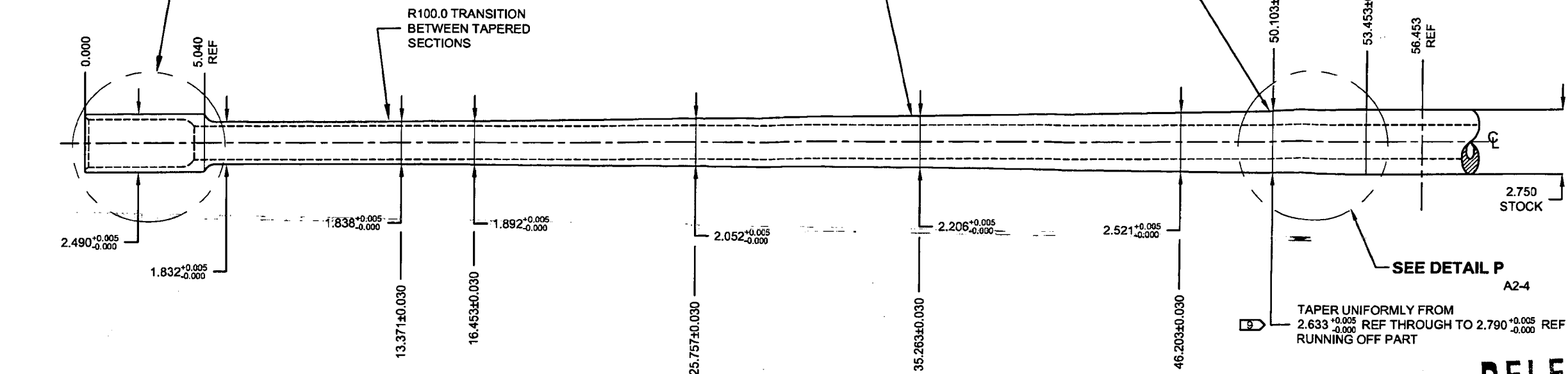




DESIGN	97	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D407-667-245	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
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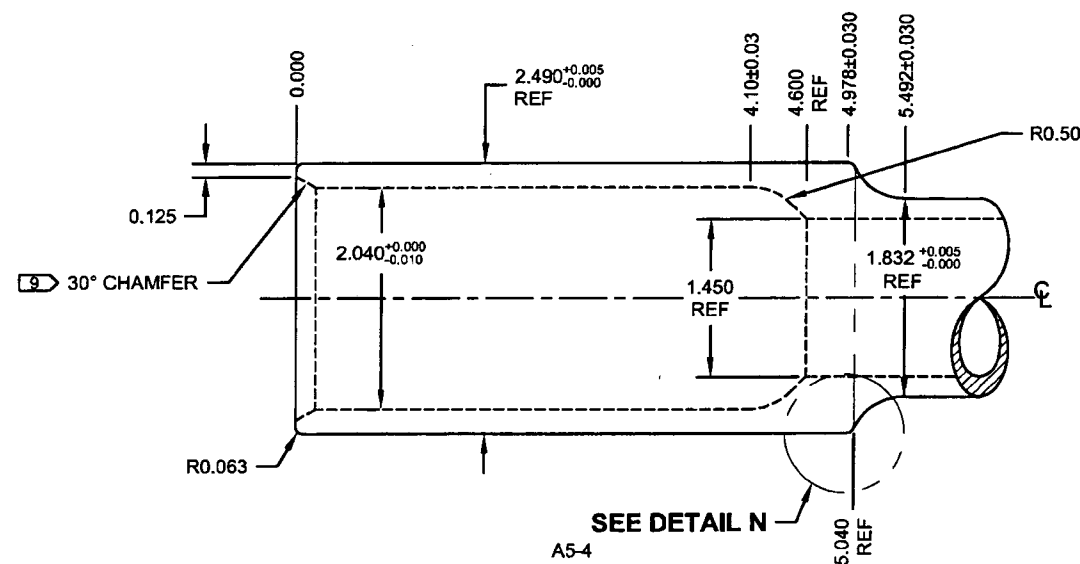


SEE DETAIL M  
A7-4

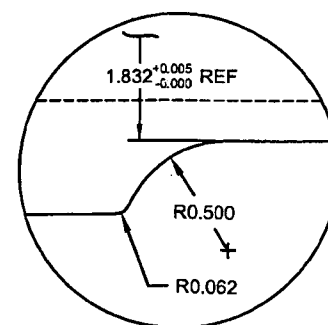


**D407-667-245 MACHINING DETAIL**

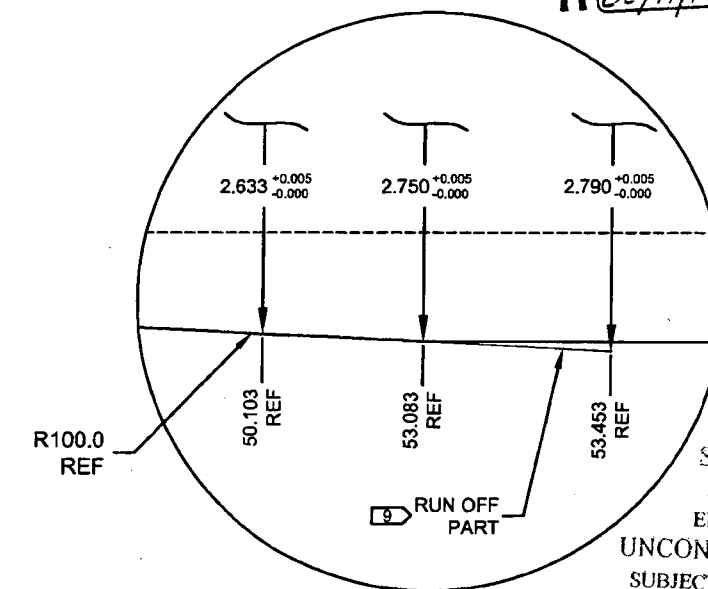
**RELEASED**  
08/11/12



**DETAIL M: CROSSTUBE CUFF**  
SCALE 3X



**DETAIL N: CUFF TRANSITION**  
SCALE 2X



**DETAIL P: TAPER RUN-OFF**  
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CHECKED	JP	DRAWING NO.	REV. F
MFG. APPR.	JP	D407-667-245	SHEET 4 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
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